Page 1

Thursday, June 02, 2011 1:30:18 PM

Item ID:

D3207-2

Revision ID: Item Name:

Bracket

Start Date:

6/9/2011

Start Qty: 10.00

Required Date: 6/17/2011

Req'd Qty: 10.00



Accept

Setup Start



Stop

Start

Stop

Reference:

Approvals:

Sequence ID/

Process Plan:

QC:

Date:

Date:

0.00

0.00

Tool ID

Cust Item ID:

Customer:

Tool # Plan

Accept

Reject

Reject

Insp.

Work Center ID Draw Nbr

Run Hours

Date:

Date:

Qty

Qty

Run

Number

Stamp

D3207

Rev A

100

Waterjet

FLOW CNC Waterjet

2074. 1050

Operation

Description

Revision Nbr

FLOW WATER JET

Memo

1-Cut as per Dwg D3207 Deburr if necessary

□Dwg Rev:

1311-6-8



110

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

0.00

PB11-6-8

120

QC

QC8- Inspect parts - second check

80)204 Boog

Quality Control

Memo

Memo

Tooling:

SPC (Y/N):

Set Up/

Code

Dart Aerospace Ltd WORK ORDER CHANGES W/O: **Approval Approval** DATE STEP PROCEDURE CHANGE By Qty Date Chief Eng / QC Inspector Prod Mgr Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ____ Date: ____ Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____ **WORK ORDER NON-CONFORMANCE (NCR)** NCR: **Corrective Action** Section B Verification **Description of NC Approval Approval STEP** DATE Sign & Initial **Action Description** QC Inspector Section A Section C Chief Eng Date Chief Eng Chief Eng

Work Order ID 70291

Thursday, June 02, 2011 1:30:18 PM

Item ID:

D3207-2

Item Name: Bracket

Required Date: 6/17/2011

Start Date:

Revision ID:

QC:

6/9/2011

Start Qty: 10.00 Req'd Qty: 10.00

Accept



Setup Start

Stop



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: Date: Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Operation

Set Up/ **Run Hours** Tool ID

Tool # Plan

Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

Sequence ID/ Work Center ID

130

Brake NC Brake NC

Description

NC BRAKE

E 11.06.22

0.00

0.00

Form 1/2 of stack for D3207-2 as per Dwg D3207 Eldentify as D3207-2

So alocler

140

Quality Control

QC5- Inspect part completeness to step on W/O



150

HandFinish Hand Finishing Chemical Conversion Coat per QSI005 4.1

0.00

Memo

Memo

0.00

BR 11-6-23

W/O:		WORK ORDER CHANGES											
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector						
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Part No:	_ PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B	-	Verification	Approval	Approval		
DATE	STEP	STEP Section A		Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector		
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Page 3

Thursday, June 02, 2011 1:30:18 PM Item ID:

D3207-2

Accept

Setup Start

Stop



Revision ID:

Start Date:

Item Name: Bracket

Required Date: 6/17/2011

6/9/2011

Start Qty: 10.00 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Tool ID

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ **Work Center ID**

160

Powdercoat

Quality Control

Operation Description

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Set Up/ **Run Hours**

0.00

HOVEN TEMPERATURE:

QC3- Inspect Part Finish

0.00

Memo

0.00

Bl 11-6-24.

180

Identify as per dwg & Stock Location:

0.00

Packaging

Memo

Packaging

0.00

Date:

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

	-									
W/O:			W	ORK ORDER CHANG	ES					ż
DATE	STEP	PRO	OCEDURE CH	ANGE	E	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	STEP	Description of NC			ion B			cation	Approval	Approval
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Work Order ID 70291

Thursday, June 02, 2011 1:30:18 PM

Item ID:

D3207-2

Revision ID:

Bracket Item Name:

Start Date:

6/9/2011

Start Qty: 10.00

Operation

Description

Req'd Qty: 10.00

Accept

Setup Start

Stop

Cust Item ID: **Customer:**

Reference:

Approvals:

Process Plan:

QC:

Date:

Date:

Date:

Run Start

Stop

Sequence ID/

Work Center ID

190

Quality Control

Memo

QC21- Final Inspection - Work Order Release

0.00

Tool ID

Tool # Plan

Accept Qty Code

Reject Qty

Reject Insp. Number

Stamp

MF,1-06-24

Required Date: 6/17/2011

Date:

Tooling:

SPC (Y/N):

Set Up/

Run Hours

0.00

										
W/O:			W	ORK ORDER CHANG	iES -					· · · · · · · · · · · · · · · · · · ·
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	1 1									1

Picklist Print

Thursday, June 02, 2011 1:30:14 PM

Work Order ID: 70291

Parent Item:

D3207-2

Parent Item Name: Bracket



Start Date: 6/9/2011

Required Date: 6/17/2011

Start Qty: 10.00

Required Qty: 10.00

Comments:

A 04.04.15 | New issue KJ/RF |

IPP Rev:B Now On Waterjet 08-01-02 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	•
M2024T3S.050		Purchased	No		-	100	sf	133.3000	0.143	1.505263				
2024-T3 050 sheet										B	11-6-6	₹		

Location Loc Qty Loc Code MAT22 133.3 117684 117684 133.3

Page 1

Dart Aerospace	Ltd
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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DART AEROSPACE LTD	Work Order:	30711
Description: Bracket	Part Number:	D3207-1
Inspection Dwg: D3207 Rev: A		Page 1 of 1

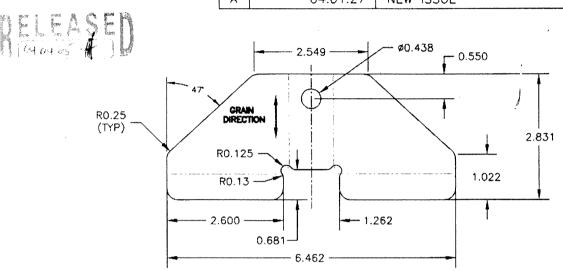
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Com	ments
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Ø0.438	+0.005/-0.000	,439	ж		V BOZ		
0.550	+/-0.010	1550	7		V	, .	
2.831	+/-0.010	2, 9,24	9		V	1	
6.462	+/-0.010	6.4160	y _		V	J	
1.262	+/-0.010	1.763	2		V		
0.681	+/-0.010	,679	\		V		
R0.125	+/-0.010	Z61,	9		Ric		
2.600	+/-0.010	2,599	8		V		
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easured by:	B 11-6-9	Audited by:	S ulocelos		Prototype Ap	proval:	N/A N/A

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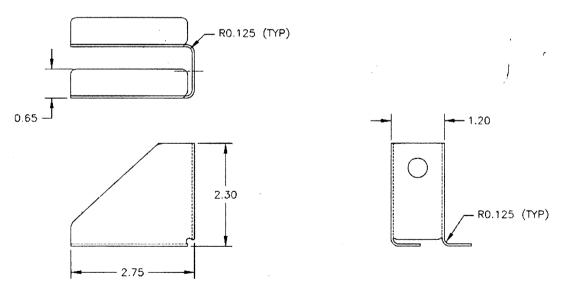




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D3207-1/-2 FLAT PATTERN



D3207-1 BEND DETAIL (SHOWN) D3207-2 OPPOSITE

D3107-1/-2 BRACKET

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.050 THICK (M2024T3S.050)
 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
 4 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 5) ALL DIMENSIONS ARE INCHES

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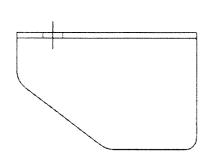
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DATE	STEP	Description of NC	Corrective Action Section			B Sign & V		cation	Approval	Approval
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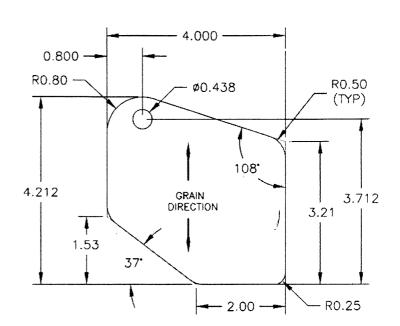




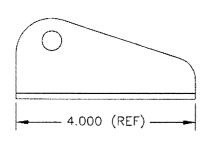
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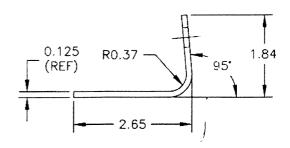






D3207-3 FLAT PATTERN





D3207-3 BEND DETAIL

D3207-3 BRACKET

1) BREAK ALL UNMARKED SHARP EDGES CORNER 0.005 TO 0.010

2) MATERIAL: 6061-T6 (QQ-A-250/11) 0.125" THICK (M6061T6S.125) 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE INCHES

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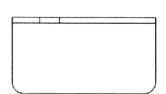
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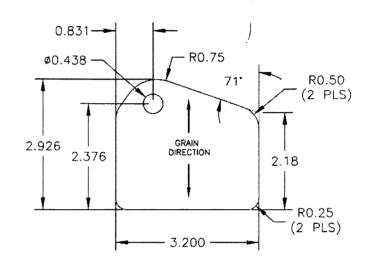




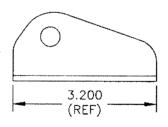
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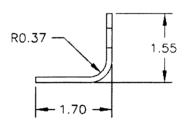






D3207-5 FLAT PATTERN





D3207-5 BEND DETAIL

D3207-5 BRACKET

- 1) BREAK ALL UNMARKED SHARP EDGES CORNER 0.005 TO 0.010
- 2) MATERIAL: 6061-T6 (QQ-A-250/11) 0.125" THICK (M6061T6S.125)
 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES

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